

図1 Fig. 1

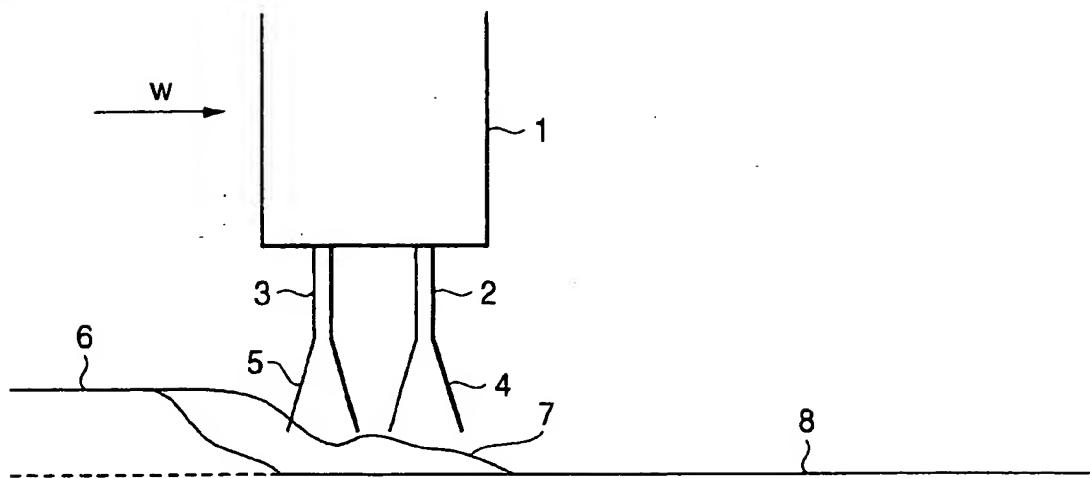


図2 Fig. 2

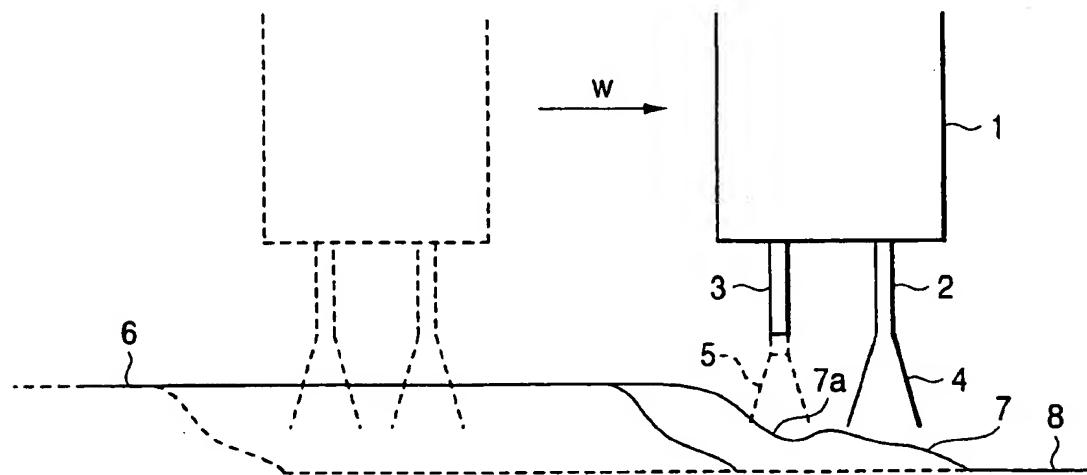


図3 Fig. 3

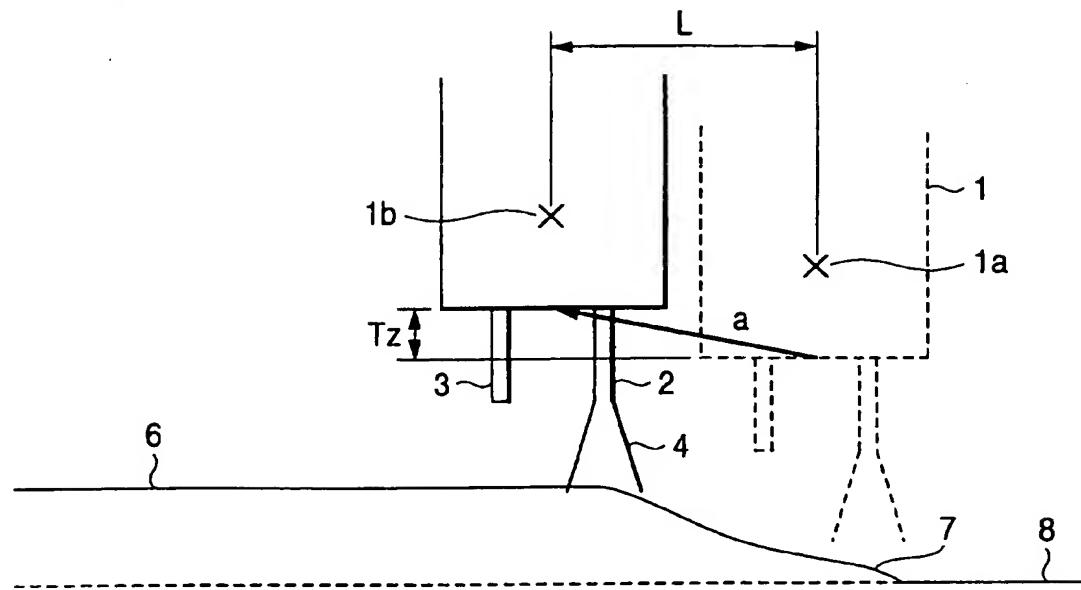


図4 Fig. 4

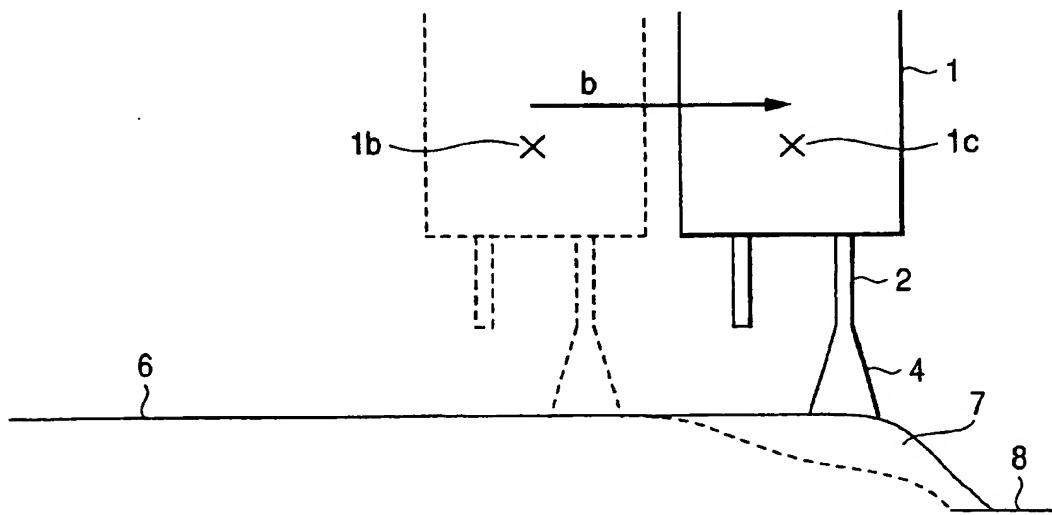


Fig. 5

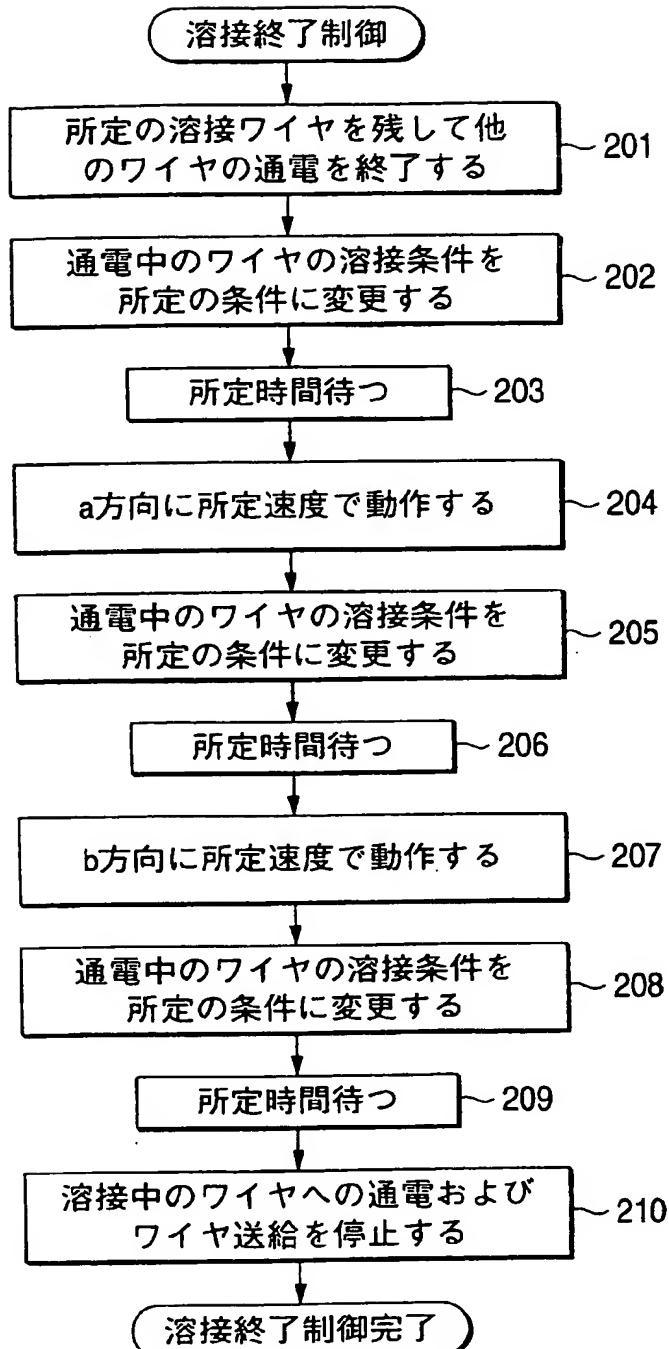


Fig. 5

WELDING TERMINATION CONTROL

201: TERMINATE ENERGIZATION OF ALL WELDING WIRES EXCEPT FOR A SPECIFIED WELDING WIRE.

202: CHANGE THE WELDING CONDITION OF THE WELDING WIRES BEING ENERGIZED TO A GIVEN WELDING CONDITION.

203: WAIT FOR A GIVEN TIME.

204: MOVE A TORCH AT A GIVEN TIME IN THE a DIRECTION.

205: CHANGE THE WELDING CONDITION OF THE WELDING WIRES BEING ENERGIZED TO A GIVEN WELDING CONDITION.

206: WAIT FOR A GIVEN TIME.

207: MOVE A TORCH AT A GIVEN TIME IN THE b DIRECTION.

208: CHANGE THE WELDING CONDITION OF THE WELDING WIRES BEING ENERGIZED TO A GIVEN WELDING CONDITION.

209: WAIT FOR A GIVEN TIME.

210: STOP ENERGIZATION AND FEEDING OF THE WELDING WIRES BEING WELDED.

END OF WELDING TERMINATION CONTROL

Fig. 6

WELDING TERMINATION CONTROL

301: TERMINATE ENERGIZATION OF ALL WELDING WIRES EXCEPT FOR A SPECIFIED WELDING WIRE.

302: CHANGE THE WELDING CONDITION OF THE WELDING WIRES BEING ENERGIZED TO A GIVEN WELDING CONDITION.

303: WAIT FOR A GIVEN TIME.

304: MOVE A TORCH AT A GIVEN TIME IN THE a DIRECTION.

305: CHANGE THE WELDING CONDITION OF THE WELDING WIRES BEING ENERGIZED TO A GIVEN WELDING CONDITION.

306: WAIT FOR A GIVEN TIME.

307: MOVE A TORCH AT A GIVEN TIME IN THE b DIRECTION.

308: CHANGE THE WELDING CONDITION OF THE WELDING WIRES BEING ENERGIZED TO A GIVEN WELDING CONDITION.

309: WAIT FOR A GIVEN TIME.

310: STOP ENERGIZATION AND FEEDING OF THE WELDING WIRES BEING WELDED.

309: WAIT FOR A GIVEN TIME.

312: CHECK ALL WELDING WIRES FOR DEPOSITION.

